

Work Order ID 51726

Page 1

Monday, August 31, 2009 8:48:12 AM

Item ID: D2282-5

Accept



Setup Start



Revision ID: E

Stop



Item Name: Tube

Start Date: 8/31/2009 Start Qty: 100.00



Cust Item ID:

Required Date: 9/10/2009 Req'd Qty: 100.00



Customer:

Reference:Approvals: Process Plan: *PL*Date: *09-8-31*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2282	Rev E								

100

Doosan DOOSAN LATHE
Doosan Memo
Doosan Lathe 1-Turn as per Dwg D2282 and Folio FA189 2-Deburr

SA 09/09/14 / AF 09.09.15

110 QC2- Inspect parts off machine FAI/FAIB

QC Memo
Quality Control

SA 09/09/14 / AF 09.09.15 (101)

120 QC8- Inspect parts - second check

QC Memo
Quality Control

88 09/09/16
(101) / 6

Work Order ID 51726

Page 2

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Accept



Setup Start



Revision ID: E

Stop



Item Name: Tube

Start Date: 8/31/2009 Start Qty: 100.00



Cust Item ID:

Required Date: 9/10/2009 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 200f

0.00

9/9/18 101x SP

Packaging

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

09/09/21 MF 09-09-18

Picklist Print

Page 1

Monday, August 31, 2009 8:48:19 AM

Work Order ID: 51726



Parent Item: D2282-5RevE



Parent Item Name: Tube

Start Date: 8/31/2009

Required Date: 9/10/2009

Comments:

Start Qty: 100.00

Required Qty: 100.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304RO.750 		Purchased		No		100	f	36.3900	18.9537 			

304 SS Roundbar .750

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	36.39	
109421	1.39	
110166	1.44	
110912	6.06	
111323	3.5	
111988	24	

E-46 *19-66* *flod-07-16*

DART AEROSPACE LTD	Work Order:	51726
Description:	Part Number:	D2282-5
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

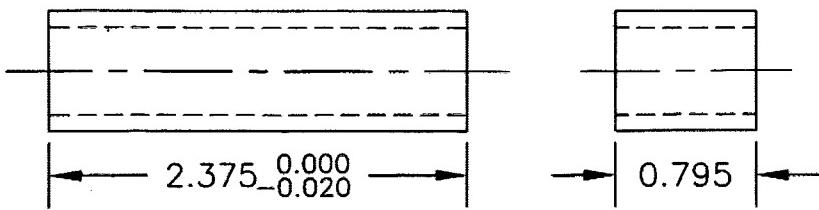
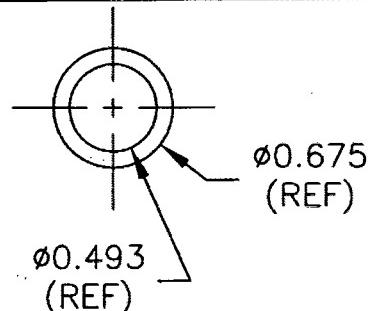
Measured by:	<u>SA</u>	Audited by:	<u>SP</u>	Prototype Approval:	N/A
Date:	<u>09/09/14</u>	Date:	<u>09/09/16</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

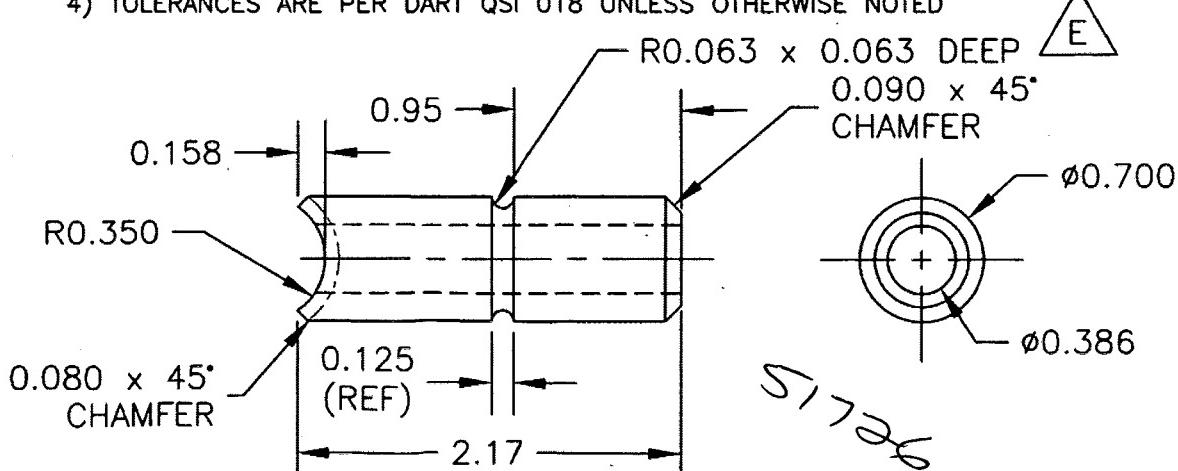
DART

DESIGN BW	DRAWN BY <i>PZ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>100%</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
BS/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

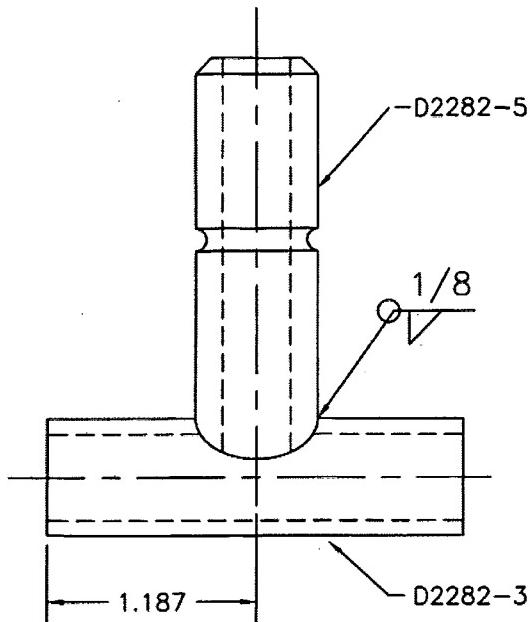
**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

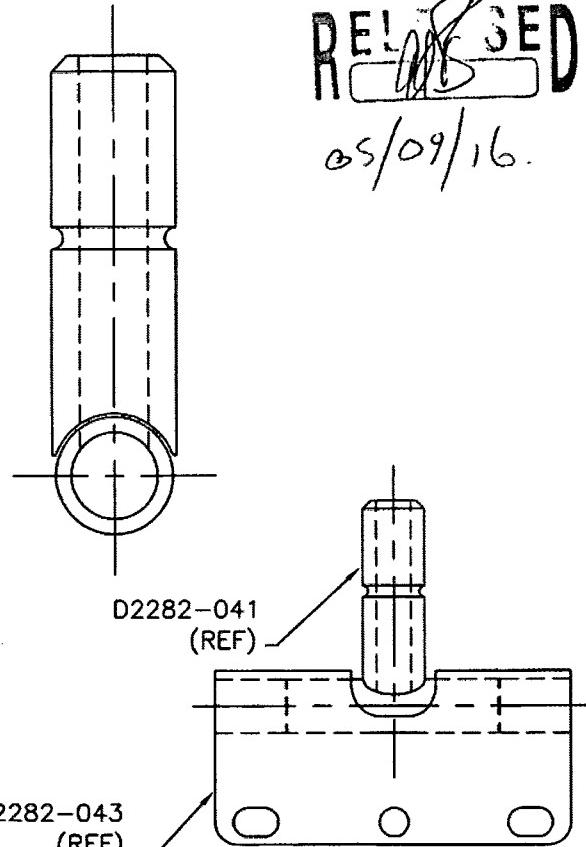
E

DART

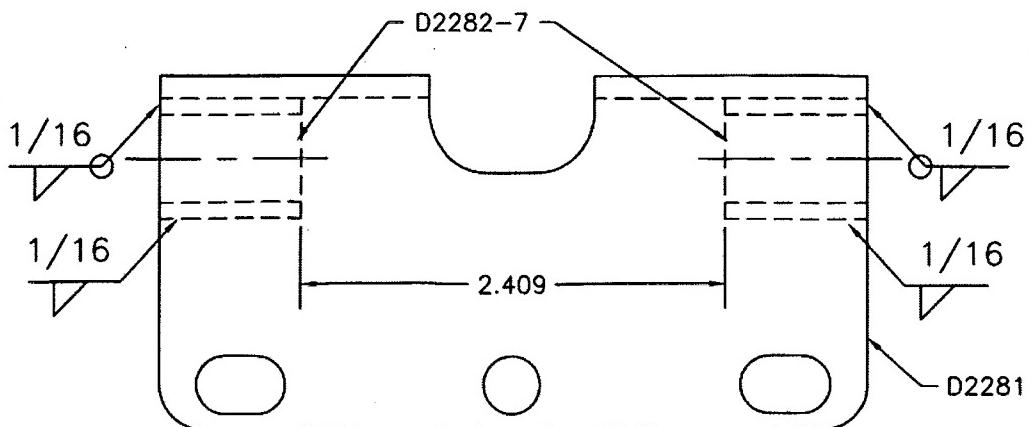
DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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